



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D350-591-213**  
**Job Sheet 180682**



Part No: D350-591-213

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 8/3/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 4 Ea  | 8/3/18     | 8/3/18   | 0.00      | 0.00    | Start Up Stores/Pkg-2 |           | JUL 25 2018 |
| 270   | Packaging          | 4 pcs | 8/3/18     | 8/3/18   | 0.00      | 0.00    | Packaging1-3          |           | 68-8        |
| 280   | QC                 | 4 pcs | 8/3/18     | 8/3/18   | 0.00      | 0.00    | QC4                   |           | 68-8        |
| 290   | Packaging          | 4 pcs | 8/3/18     | 8/3/18   | 0.00      | 0.00    | Packaging3-1          |           | 68-8        |
| 295   | DC                 | 4 pcs | 8/3/18     | 8/3/18   | 0.00      | 0.00    | DC                    |           | 68-8        |
| 300   | QC21-FG            | 4 Ea  | 8/3/18     | 8/3/18   | 0.00      | 0.00    | QC21                  |           | 68-8        |

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213  
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

### Job BOM

| Part / Item   | Component Name             | Quantity      | Operation             | Container |
|---------------|----------------------------|---------------|-----------------------|-----------|
| AN3-35A       | Bolt                       | 8 Ea (2 ea)   | 90-Start up Operation | 5087891   |
| AN4-15A       | Bolt                       | 16 Ea (4 ea)  | 90-Start up Operation | 5087424x2 |
| AN5-36A       | Bolt                       | 8 Ea (2 ea)   | 90-Start up Operation | 5071341   |
| D2230-3       | Mounting Lug               | 8 Ea (2 ea)   | 90-Start up Operation | 5083123   |
| D2618         | Bushing                    | 8 Ea (2 ea)   | 90-Start up Operation | 5082275   |
| D2732-030     | Rubber Cushion - 3"        | 16 Ea (4 ea)  | 90-Start up Operation | 5083726   |
| D3235-1       | Mounting Lug               | 8 Ea (2 ea)   | 90-Start up Operation | 5089015   |
| D3338-1       | Mounting Lug               | 4 Ea (1 ea)   | 90-Start up Operation | 5080379   |
| MS21042L3     | Nut                        | 8 Ea (2 ea)   | 90-Start up Operation | 5078167   |
| MS21042L4     | Nut                        | 24 Ea (6 ea)  | 90-Start up Operation | 5089365   |
| MS21042L5     | Nut                        | 8 Ea (2 ea)   | 90-Start up Operation | 5058178   |
| NAS1149D0363J | Washer                     | 16 Ea (4 ea)  | 90-Start up Operation | 5068661   |
| NAS1149D0463J | Washer                     | 48 Ea (12 ea) | 90-Start up Operation | 5091558   |
| NAS1149D0563J | Washer                     | 16 Ea (4 ea)  | 90-Start up Operation | 5068662x8 |
| D3078-041     | Step Assembly, Hi Short LH | 4 Ea (1 ea)   | 270-Packaging         | 50925313  |



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                      |                                                                                                                                                |                                      | Skid-tube <input type="checkbox"/>          | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/>    | Small Fab <input type="checkbox"/>     | Prod. 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Coord. <input type="checkbox"/> | Quality <input type="checkbox"/>      | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>              | Large Fab <input type="checkbox"/>        | Composite <input type="checkbox"/>        | Supplier <input type="checkbox"/> |                              |                                              |                                     |                                              |                                           |                                                |                                        |                                   |                                  |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| <div style="position: relative;"> <div style="position: absolute; top: 10%; left: 10%; transform: rotate(-45deg); font-size: 0.8em;">           Dart Aerospace Ltd.<br/>           1270 Aberdeen Street<br/>           CANADA, ON K6A 1K7<br/>           TEL.: 1 613 832-5200<br/>           Email: sales@dartaero.com<br/>           www.dartaerospace.com         </div> <div style="position: absolute; top: 40%; left: 30%; transform: rotate(-45deg); font-size: 0.8em;">           Container No: S096370<br/>           Part: D350-591-213<br/>           Job No: 180682<br/>           Serial No/Batch: S096370<br/>           Revision: _____<br/>           Inspector: _____<br/>           Exp Date: _____<br/>           Instructions: TC STC SH92-6 Issue 11, STC SH967NE 04/12/21, BRAZIL 1         </div> </div>                                                                                                                                                                                                         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             |                                             |                                     |                                    |                                      |                                       |                                        |                                            |                                       |                                        |                                    |                                              |                                             |                                           |                                           |                                   |                              |                                              |                                     |                                              |                                           |                                                |                                        |                                   |                                 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| <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <b>Root Cause</b><br/> <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment <input type="checkbox"/></td><td style="border: none;">No Re-verification <input type="checkbox"/></td></tr> <tr><td style="border: none;">Design <input type="checkbox"/></td><td style="border: none;">Operator <input type="checkbox"/></td></tr> <tr><td style="border: none;">Doc/Data <input type="checkbox"/></td><td style="border: none;">Offset/Setup <input type="checkbox"/></td></tr> <tr><td style="border: none;">Equip/Tooling <input type="checkbox"/></td><td style="border: none;">Supplier <input type="checkbox"/></td></tr> <tr><td style="border: none;">Handling/Pre <input type="checkbox"/></td><td style="border: none;">Training <input type="checkbox"/></td></tr> <tr><td style="border: none;">Material <input type="checkbox"/></td><td style="border: none;">Use for Testing <input type="checkbox"/></td></tr> <tr><td style="border: none;">Internal Transport <input type="checkbox"/></td><td style="border: none;">Poor Information <input type="checkbox"/></td></tr> <tr><td style="border: none;">Tribal Knowledge <input type="checkbox"/></td><td style="border: none;">Rushing <input type="checkbox"/></td></tr> <tr><td style="border: none;">LOA <input type="checkbox"/></td><td style="border: none;">Product Improvement <input type="checkbox"/></td></tr> <tr><td style="border: none;">Substation <input type="checkbox"/></td><td style="border: none;">Process Improvement <input type="checkbox"/></td></tr> <tr><td style="border: none;">Past Expiry Date <input type="checkbox"/></td><td style="border: none;">Manufacturing Process <input type="checkbox"/></td></tr> <tr><td style="border: none;">Misidentified <input type="checkbox"/></td><td style="border: none;">Past Due <input type="checkbox"/></td></tr> </table> </div> <div style="width: 45%;"> <table style="width:100%; 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| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Design <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Use for Testing <input type="checkbox"/>                                                                                                                                           |                                                                                                                                                                                                                                                                                                                                                                            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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Pressur <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Bendin <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Centre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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 |                                       |                                 |                                          |                                 |                                             |                                 |                                        |                                                 |                                           |                                |                                    |                                   |                                  |                                     |                                 |                                             |                                  |                                        |                                           |
| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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**Job Allocations**

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | AN3-35A        | 8        | 380       | 0         |
|                       | AN4-15A        | 16       | 445       | 0         |
|                       | AN5-36A        | 8        | 324       | 0         |
|                       | D2230-3        | 8        | 247       | 0         |
|                       | D2618          | 8        | 511       | 0         |
|                       | D2732-030      | 16       | 71        | 0         |
|                       | D3235-1        | 8        | 273       | 0         |
|                       | D3338-1        | 4        | 19        | 0         |
|                       | MS21042L3      | 8        | 1,920     | 0         |
|                       | MS21042L4      | 24       | 3,914     | 0         |
|                       | MS21042L5      | 8        | 870       | 0         |
|                       | NAS1149D0363J  | 16       | 1,444     | 0         |
|                       | NAS1149D0463J  | 48       | 7,036     | 0         |
|                       | NAS1149D0563J  | 16       | 1,587     | 0         |
|                       | D3078-041      | 4        | 0         | 0         |
| 270-Packaging         |                |          |           |           |

**Part Specifications**

Specifications could not be found.

Plex 7/12/18 7:26 AM dart.lacelle.linda



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| <b>Root Cause</b><br><table style="width:100%; border: none;"> <tr><td style="border: none;">Environment <input type="checkbox"/></td><td style="border: none;">No Re-verification <input type="checkbox"/></td></tr> <tr><td style="border: none;">Design <input type="checkbox"/></td><td style="border: none;">Operator <input type="checkbox"/></td></tr> <tr><td style="border: none;">Doc/Data <input type="checkbox"/></td><td style="border: none;">Offset/Setup <input type="checkbox"/></td></tr> <tr><td style="border: none;">Equip/Tooling <input type="checkbox"/></td><td style="border: none;">Supplier <input type="checkbox"/></td></tr> <tr><td style="border: none;">Handling/Pre <input type="checkbox"/></td><td style="border: none;">Training <input type="checkbox"/></td></tr> <tr><td style="border: none;">Material <input type="checkbox"/></td><td style="border: none;">Use for Testing <input type="checkbox"/></td></tr> <tr><td style="border: none;">Internal Transport <input type="checkbox"/></td><td style="border: none;">Poor Information <input type="checkbox"/></td></tr> <tr><td style="border: none;">Tribal Knowledge <input type="checkbox"/></td><td style="border: none;">Rushing <input type="checkbox"/></td></tr> <tr><td style="border: none;">LOA <input type="checkbox"/></td><td style="border: none;">Product Improvement <input type="checkbox"/></td></tr> <tr><td style="border: none;">Substation <input type="checkbox"/></td><td style="border: none;">Process Improvement <input type="checkbox"/></td></tr> <tr><td style="border: none;">Past Expiry Date <input type="checkbox"/></td><td style="border: none;">Manufacturing Process <input type="checkbox"/></td></tr> <tr><td style="border: none;">Misidentified <input type="checkbox"/></td><td style="border: none;">Past Due <input type="checkbox"/></td></tr> </table> |                                                                                                                                                                                    | Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | No Re-verification <input type="checkbox"/>   | Design <input type="checkbox"/>              | Operator <input type="checkbox"/> | Doc/Data <input type="checkbox"/>  | Offset/Setup <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/> | Supplier <input type="checkbox"/>    | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/>  | Material <input type="checkbox"/>          | Use for Testing <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/>    | Rushing <input type="checkbox"/> | LOA <input type="checkbox"/>       | Product Improvement <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced <input type="checkbox"/></td><td style="border: none;">Temperature/Cure <input type="checkbox"/></td><td style="border: none;">Power Loss/Surge <input type="checkbox"/></td><td style="border: none;">Positioned Wrong <input type="checkbox"/></td></tr> <tr><td style="border: none;">Bending <input type="checkbox"/></td><td style="border: none;">Set-up <input type="checkbox"/></td><td style="border: none;">Folio/Program <input type="checkbox"/></td><td style="border: none;">Outside Dimensions <input type="checkbox"/></td></tr> <tr><td style="border: none;">Centre Not Concentric <input type="checkbox"/></td><td style="border: none;">BOM/Route <input type="checkbox"/></td><td style="border: none;">Grain <input type="checkbox"/></td><td style="border: none;">Over/Under tolerance <input type="checkbox"/></td></tr> <tr><td style="border: none;">Cracks <input type="checkbox"/></td><td style="border: none;">Broken/Damage/Defect <input type="checkbox"/></td><td style="border: none;">Weld <input type="checkbox"/></td><td style="border: none;">Part Incorrect <input type="checkbox"/></td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave <input type="checkbox"/></td><td style="border: none;">Inspection Incomplete/Unqualified <input type="checkbox"/></td><td style="border: none;">Wrong Stock Pulled <input type="checkbox"/></td><td style="border: none;">Part Lost/Missing <input type="checkbox"/></td></tr> <tr><td style="border: none;">Cuffs <input type="checkbox"/></td><td style="border: none;">Contamination <input type="checkbox"/></td><td style="border: none;">Out of Sequence <input type="checkbox"/></td><td style="border: none;">Part Moved <input type="checkbox"/></td></tr> <tr><td style="border: none;">Crushing <input type="checkbox"/></td><td style="border: none;">Countersink <input type="checkbox"/></td><td style="border: none;">Off-set <input type="checkbox"/></td><td style="border: none;">Drawing <input type="checkbox"/></td></tr> <tr><td style="border: none;">Heat Treat <input type="checkbox"/></td><td style="border: none;">Cut Too Short <input type="checkbox"/></td><td style="border: none;">Mislabeled <input type="checkbox"/></td><td style="border: none;">Finish <input type="checkbox"/></td></tr> <tr><td style="border: none;">Wave/Twist in Tube <input type="checkbox"/></td><td style="border: none;">Instructions Incomplete/Unclear <input type="checkbox"/></td><td style="border: none;">Fit/Function <input type="checkbox"/></td><td style="border: none;">Misread <input type="checkbox"/></td></tr> <tr><td style="border: none;">Marks/Chatter <input type="checkbox"/></td><td style="border: none;">Drill Holes <input type="checkbox"/></td><td style="border: none;">Misaligned/off center <input type="checkbox"/></td><td style="border: none;">Turning Sequence <input type="checkbox"/></td></tr> </table> |  |  | Pressure/Forced <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Bending <input type="checkbox"/> | Set-up <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Weld <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Off-set <input type="checkbox"/> | Drawing <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Finish <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Misread <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/> |
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| Equip/Tooling <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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          | Out of Sequence <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Part Moved <input type="checkbox"/>           |                                              |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              |                                         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| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Countersink <input type="checkbox"/>                                                                                                                                               | Off-set <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Drawing <input type="checkbox"/>              |                                              |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              |                                         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                  |                                          |                                     |                                   |                                      |                                  |                                  |                                     |                                        |                                     |                                 |                                             |                                                          |                                       |                                  |                                        |                                      |                                                |                                           |
| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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          | Mislabeled <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Finish <input type="checkbox"/>               |                                              |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              |                                         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                  |                                          |                                     |                                   |                                      |                                  |                                  |                                     |                                        |                                     |                                 |                                             |                                                          |                                       |                                  |                                        |                                      |                                                |                                           |
| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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          | Fit/Function <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Misread <input type="checkbox"/>              |                                              |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              |                                         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| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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          | Misaligned/off center <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Turning Sequence <input type="checkbox"/>     |                                              |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              |                                         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| Qty<br>-213 | Qty<br>-214 | Qty<br>-215 | Qty<br>-216 | Qty<br>-311 | Qty<br>-312 | Part Number   | Description                                   |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-----------------------------------------------|
| X           | X           |             |             |             |             | D350-591-213  | Heli-Access-Step™, Short Step – High Skid, LH |
|             |             |             |             |             |             | D350-591-214  | Heli-Access-Step™, Short Step – High Skid, RH |
|             |             | X           |             |             |             | D350-591-215  | Heli-Access-Step™, Short Step – Low Skid, LH  |
|             |             |             | X           |             |             | D350-591-216  | Heli-Access-Step™, Short Step – Low Skid, RH  |
|             |             |             |             | X           |             | D350-591-311  | Heli-Access-Step™, Long Step – High Skid, LH  |
|             |             |             |             |             | X           | D350-591-312  | Heli-Access-Step™, Long Step – High Skid, RH  |
| 1           | 1           |             |             |             |             | D3078-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                |
|             |             |             |             |             |             | D3078-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                |
|             |             | 1           |             |             |             | D3168-041     | STEP ASSEMBLY (LOW-SHORT, LH)                 |
|             |             |             | 1           |             |             | D3168-042     | STEP ASSEMBLY (LOW-SHORT, RH)                 |
|             |             |             |             | 1           |             | D3272-041     | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             |             |             |             |             | 1           | D3272-042     | STEP ASSEMBLY (HIGH-LONG, RH)                 |
| 2           | 2           | 2           | 2           | 4           | 4           | D2230-3       | MOUNTING LUG                                  |
| 2           | 2           | 2           | 2           | 2           | 2           | D2618         | BUSHING                                       |
| 4           | 4           | 4           | 4           |             |             | D2732-030     | CUSHION                                       |
|             |             |             |             | 2           | 2           | D2856-400-720 | ABRASION STRIP                                |
| 2           | 2           | 2           | 2           | 2           | 2           | D3235-1       | MOUNTING LUG                                  |
|             |             |             |             | 1           | 1           | D3278-041     | SUPPORT ASSEMBLY                              |
| 2           | 2           | 2           | 2           | 2           | 2           | AN3-35A       | BOLT                                          |
|             |             |             |             | 8           | 8           | AN4-13A       | BOLT                                          |
| 4           | 4           | 4           | 4           |             |             | AN4-15A       | BOLT                                          |
| 2           | 2           | 2           | 2           | 2           | 2           | AN5-36A       | BOLT                                          |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0363J | WASHER (AN960JD10)                            |
| 12          | 12          | 12          | 12          | 16          | 16          | NAS1149D0463J | WASHER (AN960JD416)                           |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0563J | WASHER (AN960JD516)                           |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L3     | NUT                                           |
| 6           | 6           | 6           | 6           | 8           | 8           | MS21042L4     | NUT                                           |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L5     | NUT                                           |
|             |             |             |             | 1           | 1           | *DSI 9410-011 | STEP MODIFICATION KIT                         |

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.





# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3  
REF TCCA STC: SH92-6  
REF FAA STC: SH967NE

## 1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

## 2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in  $\pm$  1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

## 3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

| Qty<br>-133 | Qty<br>-213 | Qty<br>-214 | Part Number  | Description                                   |
|-------------|-------------|-------------|--------------|-----------------------------------------------|
| X           |             |             | D350-591-133 | Heli-Access-Step™, Aft Maintenance Step       |
|             | X           |             | D350-591-213 | Heli-Access-Step™, Short Step – High Skid, LH |
|             |             | X           | D350-591-214 | Heli-Access-Step™, Short Step – High Skid, RH |
| 1           | 1           |             | D3338-1      | MOUNTING LUG (ADD)                            |

## 4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

| Qty<br>-011 | Part Number  | Description      |
|-------------|--------------|------------------|
| X           | DSI 9712-011 | Mounting Lug Kit |
| 1           | D3338-1      | MOUNTING LUG     |

## 5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 14.12.04  
CERT. NO.: SH92-6  
ISSUE NO.: 11

|            |             |                                                                                                                                                                                                                                                                                |              |
|------------|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE   | MB                                                                                                                                                                                                                                                                             | 14.10.22     |
| REV.       | DESCRIPTION | BY                                                                                                                                                                                                                                                                             | DATE         |
| DESIGN     | <u>1</u>    | DART AEROSPACE LTD                                                                                                                                                                                                                                                             |              |
| DRAWN      | <u>1</u>    | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                    |              |
| CHECKED    | <u>1</u>    | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. A       |
| MFG. APPR. | N/A         | DSI 9712                                                                                                                                                                                                                                                                       | SHEET 1 OF 3 |
| APPROVED   | <u>1</u>    | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   | <u>1</u>    | INSTALLATION OPTION                                                                                                                                                                                                                                                            | NTS          |
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## Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

